

Date: Thursday, 11/23/2006 1:09:55 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 29686  
 Estimate Number : 12593  
 P.O. Number : *N/A* Part Number : D30415  
 This Issue : 11/23/2006 S.O. No. : *N/A* Drawing Number : D3041REV.C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : *UNDER REVIEW* CB 06.11.24  
 Previous Run : *N/A* Material : *N/A*  
 Written By : Due Date : 11/30/2006 Qty: 12 Um: Each  
 Checked & Approved By : *06 11 23*  
 Comment : Est:A 01.07.11 New Issue SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.1094 f(s)/Unit Total : 1.3129 f(s)  
 Lug Extrusion  
 (D2423) Batch: *B23779*

*M8 06/11/26*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut D2423 Extrusion: 1.250" Long

*M8 06/11/26 12H*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

*RG*



*Issue P.O. 2570*



*c 206/11/27*

Comment: HAAS CNC VERTICAL MACHINING #1  
 Check for cracks while loading into the machine  
 Machine as per Folio FA and Dwg D3041  
 Tumble and Deburr rough edges after tumbling  
 Identify as D3041-5

*Machine per drawing D3041 Rev-C*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*RG*



*Review + inspect for transit*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*damage 06/12/01 (12)*

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

*Inspect level 5*

*11/06/12/02 (12)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DB Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLAMP

Job Number: 29686

Part Number: D30415

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*yl 06/12/02 x 12*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Ham 06/12/02 x 12*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*4/12/04 (12)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*4/12/04 (12)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/04 (12)*

Job Completion



*C Loc 112104*

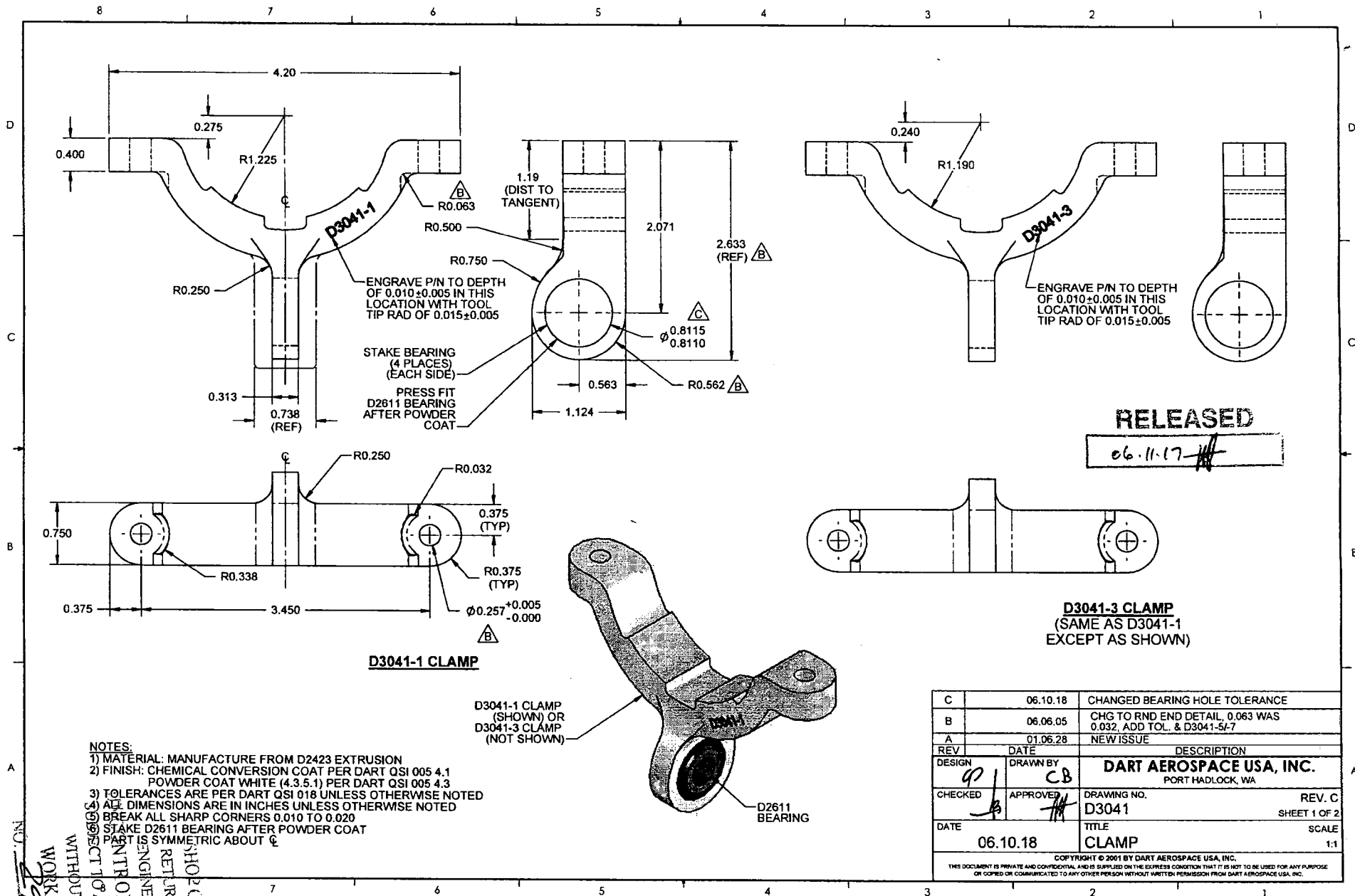
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

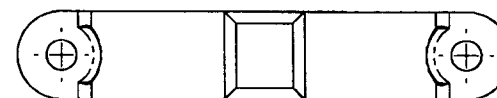
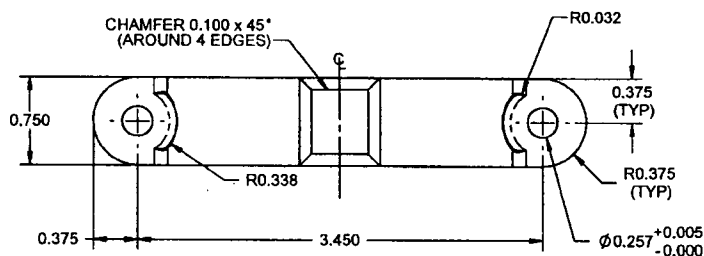
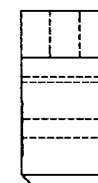
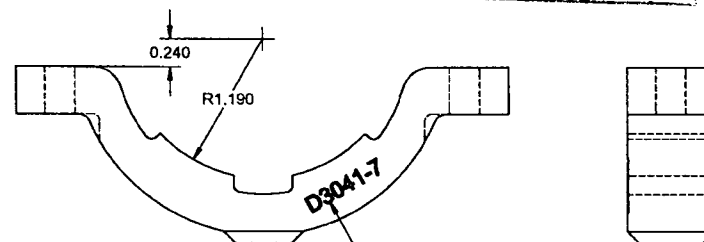
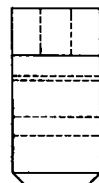
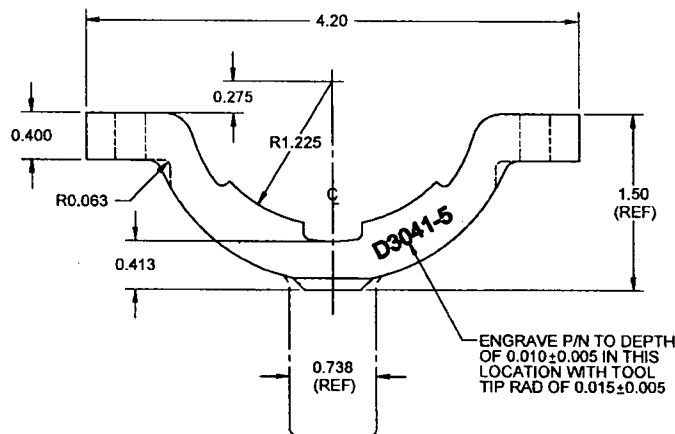
**NOTE:** Date & initial all entries



NO. 29686  
WORK ORDER  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY  
CONTROLLED COPY  
SUBJECT TO AMENDMENT

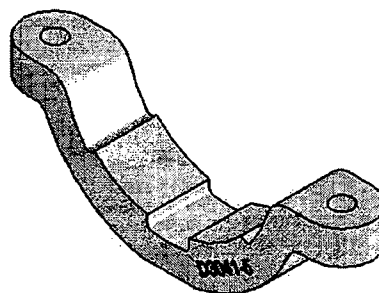
RELEASED

06.11.17



**D3041-7 CLAMP**  
(SAME AS D3041-5  
EXCEPT AS SHOWN)

**D3041-5 CLAMP**



**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT C

DESIGN 901	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1	
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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

12  
12

D3041-5  
D3041-7

Clamp B29686  
Clamp B29687

2570  
2570

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, December 1, 2006

